

Date: Wednesday, 22/10/2008 10:31:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR ASSEMBLY
Job Number	: 42786B		
Estimate Number	: 12509		
P.O. Number	:	Part Number	: D206746043
This Issue	: 22/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: DSI9341 REV C
First Issue	: 22/10/2008	Project Number	: N/A
Previous Run	: 37192	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 20/11/2008
Checked & Approved By	: <u>20.08.10.22</u>	Qty:	1 Um: Each
Comment	: est rev A 06.08.21 New Issue EC Est rev B 07.03.15 DSI 9341 Rev B KJ Est Rev:C 08-02-12 change to rev.c DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-043 CHG 001

N/A HJ

2.0	D3471041	Blower Motor Support
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BLOWER MOTOR SUPPORT

Batch:

B37114 B34008
 B42 902

SS 08/10/27
 SS 09/10/22
 SS 08/10/27 (XL)

3.0	D3473041	Blower Inlet Adapter
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BLOWER INLET ADAPTER

Batch:

B37114

SS 08/10/27 (XL)

4.0	D3476041	Blower Motor Adapter
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

blower motor adapter

Batch:

34068

SS 08/10/27

5.0	D3477041	Blower Motor Inlet Adapter
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blower Motor Inlet Adapter

Batch:

B336432

SS 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: * Wednesday, 22/10/2008 10:31:01 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 42786B

Part Number: D206746043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D35851	Set Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
SET SCREW 31571

SS 08/10/24 (X1)

7.0	D37421	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Bearing- 36967
Batch:

u see attached

8.0	26D71	Blower Motor
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
JANITROL BLOWER MOTOR ASSEMBLY
Batch: M106802

SS 09/10/18

9.0	AN33A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Bolt
Batch: M69632

SS 08/10/24 (X1)

10.0	AN96010	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Washer
Batch: 5519

SS 08/10/24 (X1)

11.0	MS270390804	SCREW
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
SCREW

No qty 1/1A

09-0622
u already on original motor

12.0	MS353338	LOCK WASHER
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
LOCK WASHER M107063

SS 08/10/24 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 10:31:01 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 42786B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Change bearing - D3742-1 B Batch: B36967
Assemble as per dwg DSI 9341

09.01.22

Center punch set-screw ,then drill as per dwg.

Add locktite 26221 to fan set screw batch: 111005

FF 09/01/19

Secure using Lock Wire

A/R MS20995-025E LOCK WIRE

BATCH:

118670

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/21

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-043

Location:

PPP Rev:

42786

9/1/22

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/23

MF 09-01-22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV. A
REF. CANADIAN STC: SH05-45 ISSUE 1
FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty -043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
		2	D3585-1	SET SCREW
		2	D3742-1	BEARING
		A/R	26221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42786B

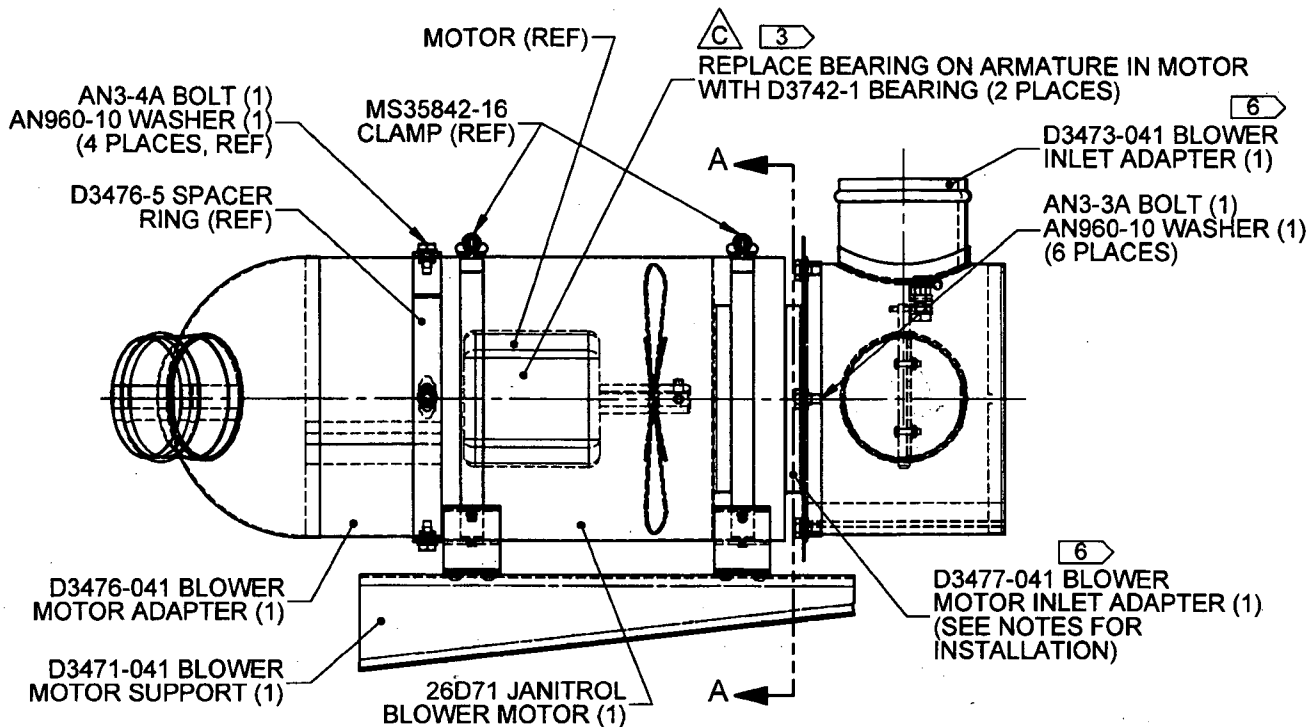
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

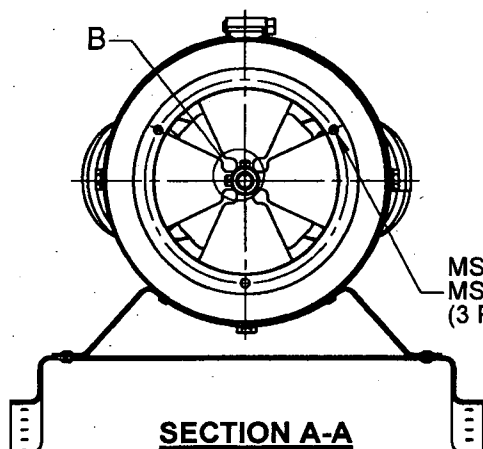
BY: D. SHEPHERD (DE # 02)

DATE: 08.01.20
CERT. NO.: SH05-45
ISSUE NO.: 1

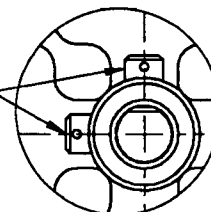
C	ADD D3742-1 BEARING; UPDATE FORMAT	PH	08.01.20
B	ADD D3585-1 & DETAIL B	MB	07.01.02
A	NEW ISSUE	MB	06.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		DSI 9341	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BLOWER MOTOR ASSEMBLY	NTS
DATE	08.01.20	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D206-746-043 BLOWER MOTOR ASSEMBLY



262 by 220.19
 4
 REPLACE EXISTING SET SCREWS WITH D3585-1 SET SCREWS (2), APPLY LOCTITE 226, TORQUE TO 50-70 in-lbs (5.6-7.9 N-m) AND SECURE USING MS20995-025E LOCK WIRE



DETAIL B
 SCALE 1:1

1
 MS27039-08-04 MACHINE SCREW (1)
 MS35333-38 LOCK WASHER (1) (3 PLACES)

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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

INSTALLATION NOTES:

- 1) ON 26D71 BLOWER MOTOR: REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1)
- 2) REMOVE MOTOR AND RETAIN HARDWARE
- 3) REPLACE BEARINGS WITH D3742-1 BEARINGS (2 PLACES)
- 4) REPLACE SET SCREWS WITH D3585-1 SET SCREWS (2 PLACES)
- 5) RE-INSTALL MOTOR WITH HARDWARE REMOVED AT STEP 2
- 6) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041/D3477-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 7) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: D. Shepherd
 D. SHEPHERD (DE # 02)

DATE: 08.01.20
 CERT. NO.: SH05-45
 ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	EE	DSI 9341	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BLOWER MOTOR ASSEMBLY	1:4
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Date: Thursday, 22/01/2009 7:36:39 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37395	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10804	DWG Name	: 26D71 MOTOR
Purchase Order #	:	Part Number	: REWORK20
Complete Date	: 18/12/2008 8:10:44	DWG Number	: ECN1128 - REWORK
Rev.	:		

DUE DATE	ORDERED	DELIVERED
20/02/2008	1	0

3.0 D37421-Bearing	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	
18/12/2008	LACE01: Lacelle, Linda	D37421	3.000	\$75.23	Lot # 36967 Qty. 3

Subtotal:	QTD:	0	CTD:	3	\$75.23
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	TIME	COST
Machine Time:	0.00	\$0.00
Labor:	0.00	\$0.00
Sub-contract (external Op.):		\$0.00
INVENTORY ITEM:		\$75.23
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$75.23

COST PER UNIT:	\$75.23
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